

Date: Monday, 18/06/2007 9:26:30 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY POD
Job Number	: 32916		
Estimate Number	: 12400		
P.O. Number	: <i>N/A</i>	Part Number	: D350602013
This Issue	: 18/06/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2202F,DEO9217A2694G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: F/A/G
Previous Run	: 30460	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 28/06/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: A New Issue 06-05-01 JLM Est Rev: B Added D3495-1 06-05-17 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD206-602-013	CHG001
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2.0	D30011	Doubler
-----	--------	---------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Doubler
 Batch: _____
 Ship to Delastek

3.0	D30481	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Doubler
 Batch: *B30519.2*
 Ship to Delastek

4.0	PG	PURCHASING
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Comment: PURCHASING
 Issue P/O: _____
 Description: _____
 D2202-1 Lid
 D2202-5 Base
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship Parts From Step 2 & 3

part D350-602011 from sth
B 29003

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

NIA

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2202 and DSI 9217. Visual inspection. Check for void spot and pins.

7.0

AD64ABS

Pop Rivets



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pop Rivets

Batch: M19109

07 06 19

8.0

MS24693S272

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Screw

Batch:

NIA

9.0

D22049

Rubber Latches



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rubber Latches

Batch:

NIA

10.0

D2429041

Spring Clip Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spring Clip Ass'y

Batch:

NIA

11.0

D2462

Neoprene Seal



Comment: Qty.: 14.1660 f(s)/Unit Total : 14.1660 f(s)

Neoprene Seal 170.0" long

Batch:

NIA

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Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D25281

Backer Plate



NIAJ

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Backer Plate

Batch: _____

13.0

D25283

Backer Plate



NIAJ

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backer Plate

Batch: _____

14.0

D2569

Hinge



NIAJ

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge

Batch: _____

15.0

D3007041

Strut



NIAJ

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: _____

16.0

AD64ABS

Pop Rivets



NIAJ

Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pop Rivets

Batch: _____

17.0

AN45A

Bolt



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Bolt

Batch: _____

18.0

AN46A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: _____

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN526C632R7

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch: _____

20.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: _____

21.0

AN960JD416

Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Batch: _____

22.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Batch: _____

23.0

MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: _____

24.0

D2258160

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Assemble as per Dwg D2694

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2694

07 06 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 9/16/26
 QA: N/C Closed: _____ Date: _____

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Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Install label D2258-160 on Pod Assembly as per Dwg D2694

3-Modify as per DEO 9217

26.0

QC5

INSPECT WORK TO CURRENT STEP



Ins 25 @



Comment: INSPECT WORK TO CURRENT STEP

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

K10002

350 Pod Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

350 Pod Kit

Batch: *1-2-25*

B 26679

29.0

D34951

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PLACARD

BATCH: *1-2-25*

B 27162

CU 2/3/25

30.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10/2/26 (1)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-602-013

Location: *A*

PPP Rev: *2*

10/2/26 (1)

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/2/26 (1)

Job Completion



10/2/26

W/O:		WORK ORDER CHANGES					
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DESIGN <i>A</i>	DRAWN BY <i>A</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. DEO 9217	REV. A SHEET 1 OF 1
DATE 01.09.26		TITLE MOsaic POD MODIFICATION	
A	01.09.26	NEW ISSUE	

AD64ABS M19109
~~MS24693S272 H104746~~
DART ENGINEERING ORDER

TO AMEND D2202 REV. F

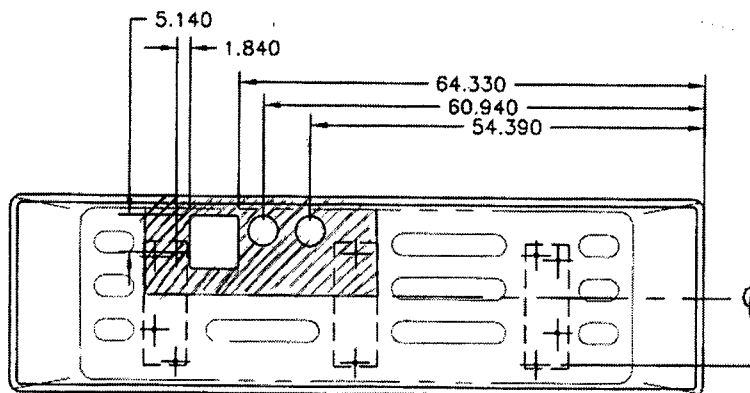
TO MAKE A D2202-5 BASE (FOR D350-602-013) FROM A D2202-3 BASE :

- 1) REMOVE FOAM IN SHADED AREA OF POD.
- 2) FILL GAPS WITH 902 SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 902 SATIN M101039 902 cloth 4ft
- 4) INSTALL D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) INSTALL DOUBLER WITH AD64ABS RIVETS (46) AND ~~MS24693S272~~ SCREWS (3)
- 6) CUT HOLES AND SEAL WITH CYANOACRYLATE GLUE
- 7) ~~TOUCH UP SPARKLE GREY FINISH AND CLEARCOAT~~ Prime with Dupont 2K urethane primer for Q5100S.

Resin 9309 A/B M102477 600g
 9309 A/B M103866 250g

RELEASED

04.10.14 *A*



HINGE SIDE

D2202-5 POD BASE

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AF</i>	APPROVED <i>AF</i>	DRAWING NO. D2694	REV. G SHEET 1 OF 4
DATE 01.05.08		TITLE UTILITY POD ASSEMBLY SCALE NTS	
A	97.07.02	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	
B	97.10.08	CHANGE RIVET PATTERN, ADD D2429	
C	98.11.12	ADD DOUBLER HOLES, REMOVE FINISH	
D	99.01.08	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DE09119	
E	99.12.20	CHANGE DIMENSIONS	
F	01.03.20	REDESIGN, CHANGE LATCHES & PROP	
G	01.05.08	REVERT BACK TO D2204-9 LATCH	

RELEASED
01.05.16 *AF*

Qty	Part Number	Description
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2462-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD64ABS	RIVET

32966

GENERAL NOTES:

- TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141
AN4 → DRILL Ø0.257
- SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE.
- FOR D2569 HINGE:
 - INSTALL RIVET HEADS FROM OUTSIDE OF POD.
 - GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE.
 - ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.

DART		TEL.: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D350-602-011	CHG	CHG005
DESC	Heli-Utility-Pod	STC	SH93-97
LOT	B29003	STC	SR01144NY
MODEL	AS350	STC	
MADE IN CANADA			

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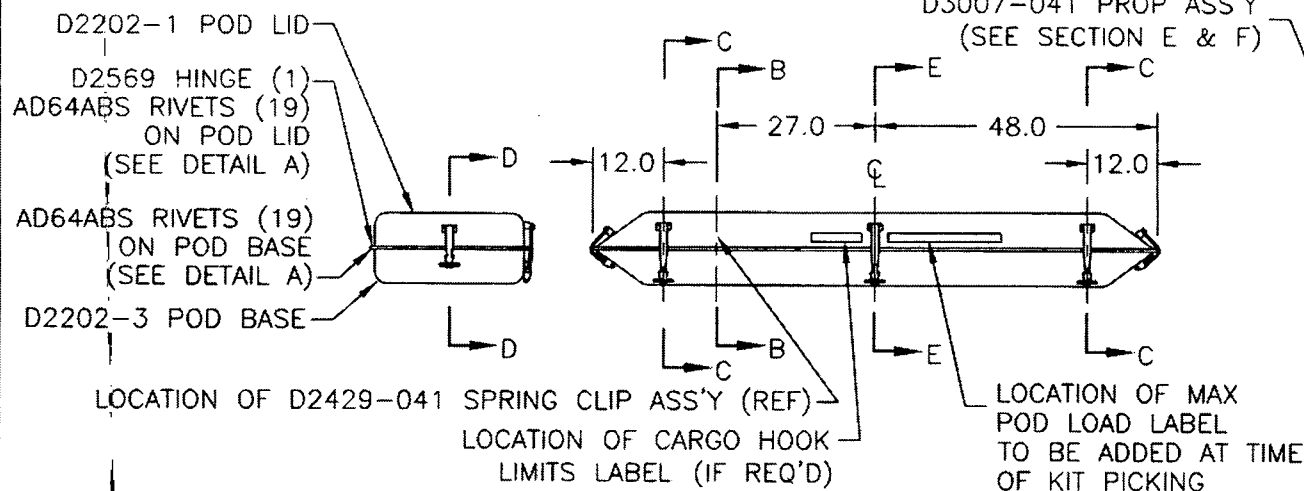
NOTE: Date & initial all entries

DART



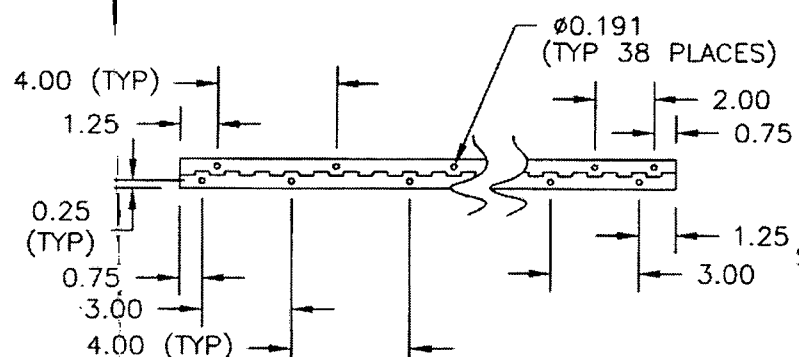
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 01.05.08	DRAWING NO. D2694	REV. 6
	TITLE UTILITY POD ASSEMBLY	SHEET 2 OF 4
		SCALE 1:30

D3007-041 PROP ASS'Y
(SEE SECTION E & F)

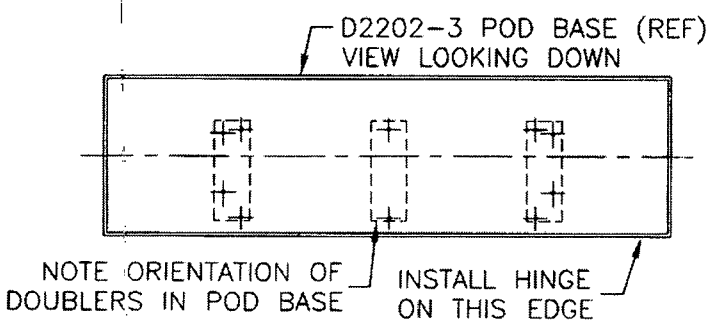
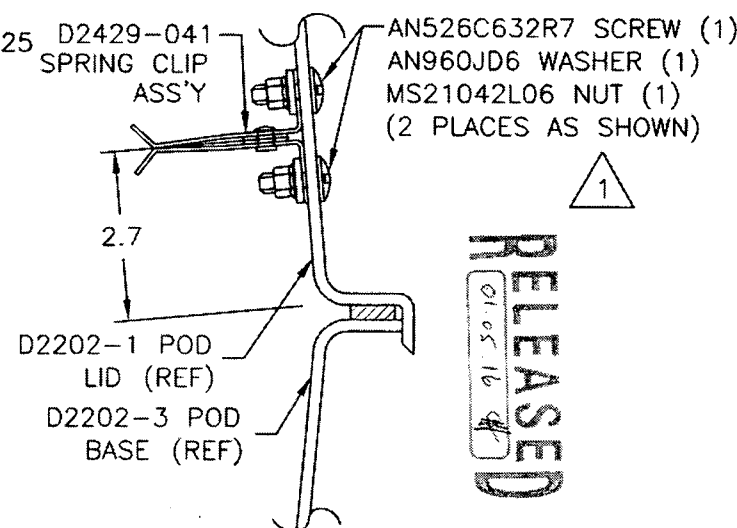


INSTALL D2462-1700 NEOPRENE SEAL ALONG TOP INSIDE EDGE OF LID (USE CONTACT CEMENT)

DETAIL A: HINGE
NOT TO SCALE



SECTION B-B
SCALE 2:3



RELEASED
01.05.16

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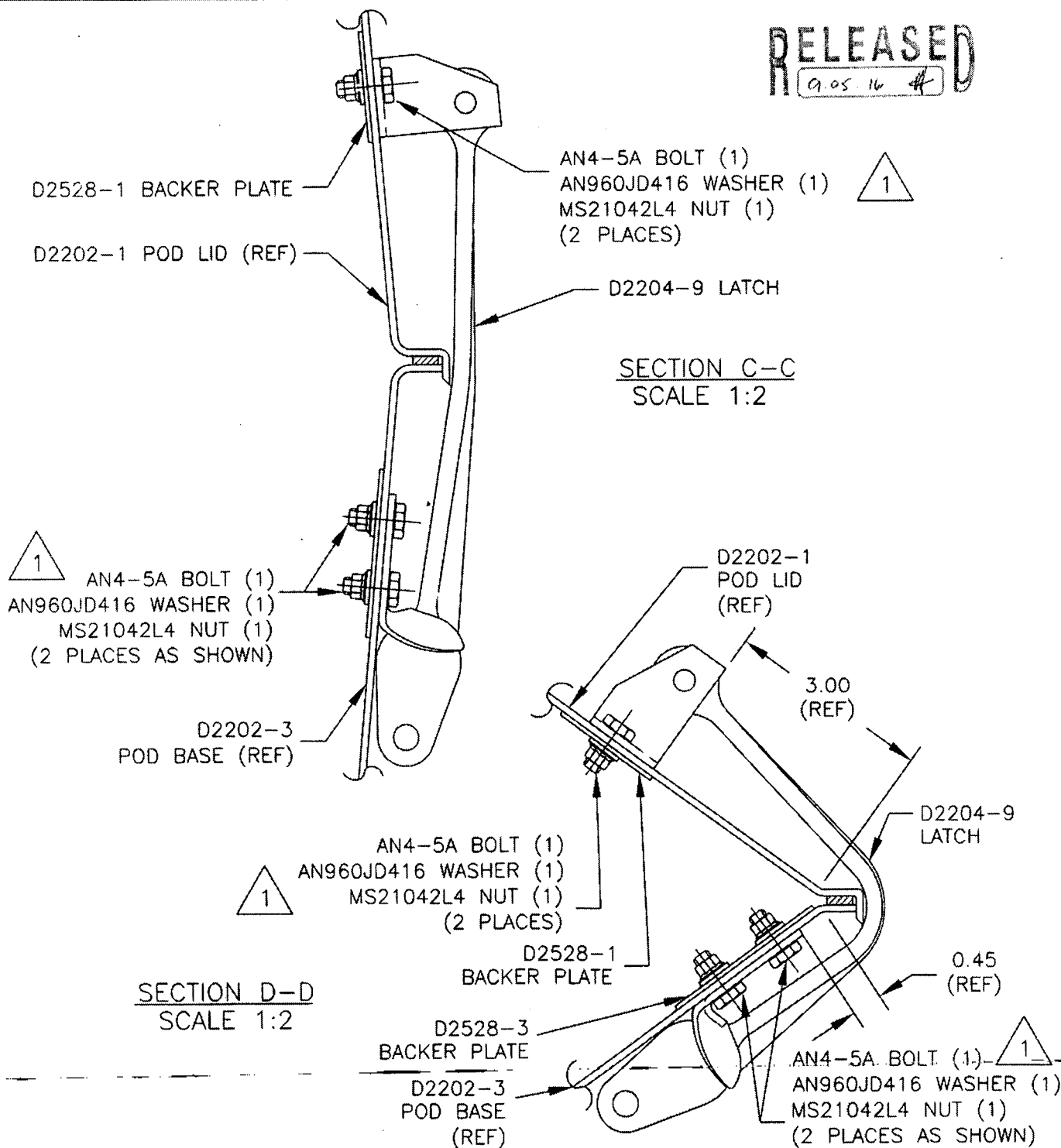
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2694	REV. G SHEET 3 OF 4
DATE 01.05.08		TITLE UTILITY POD ASSEMBLY	SCALE 1:2

RELEASED
9.05.16 #



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